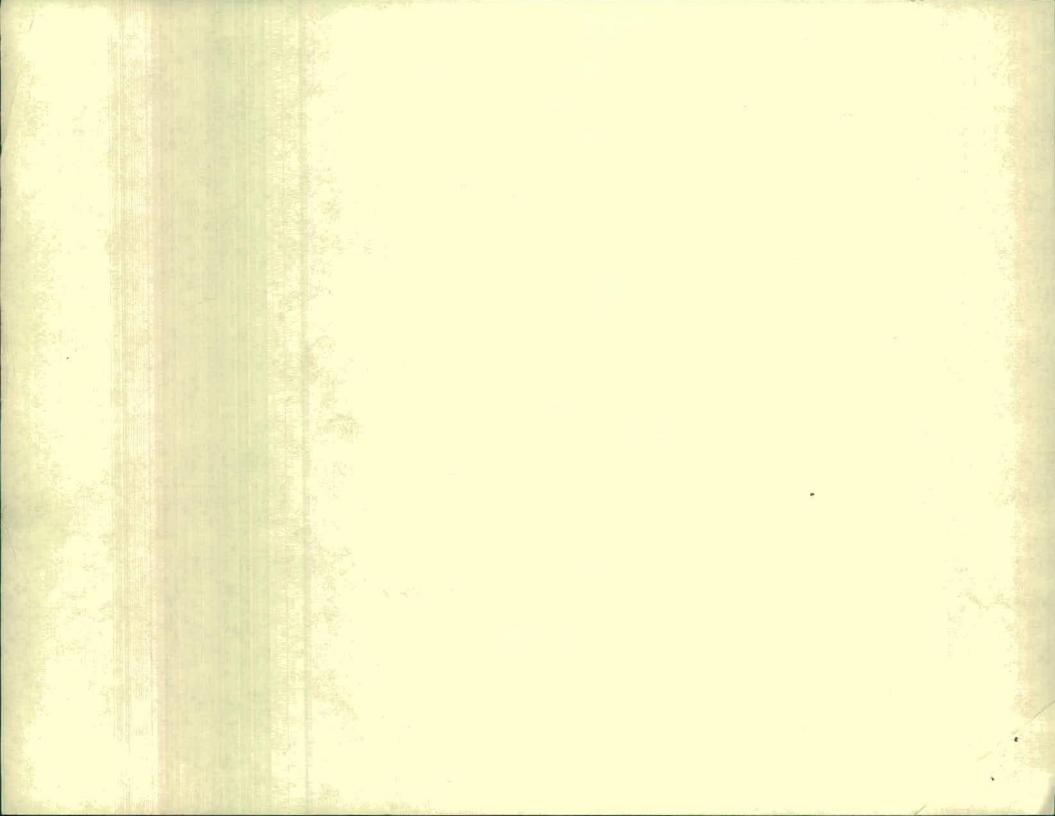
Monday, 2/5/2007 8:06:57 AM SPLIT-R Kim Johnston **Process Sheet** : SADDLE FITTING, FWD (OUTBOARD/INBOARD) **Drawing Name** Customer : CU-DAR001 Dart Helicopters Services ob Number 30592 : 10530 stimate Number O. Number NIA Part Number : D2571 S.O. No. : N// : D2571 REV E 2/5/2007 Drawing Number Inis Issue Project Number : N/A Frsh! Rev. MA : MACHINED PARTS Type Drawing Revision First Issue : 30212 Frevious Run Material : 2/15/2007 Each Due Date Written By necked & Approved By : Est: 1 02 40.02 Re-formal, Change to Dwg Rev. D & piriment incorporated D2572 KJ aditional Product Thanks. 569 F Machine Or Operation: Description: 7075-T7351 8.25X7 75X2.5 E 101007 Comment Qtv. 1 0000 Each(s)/Unit Total 12.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2571 Ensure that grain is along 7.75" length M807/04/20 25354 (3) Batch No: 75355 HAAS CNC VERTICAL MACHINING #1 Comment. HAAS ONG VERTICAL MACHINING #1 Program Batch No. 336542 Double check by: JF - J.L 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburt and remove all machining marks 5-Tumble to remove sharp edges. MILING CONV CONVENTIONAL MILLING MACHINE Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572 INSPECT PARTS AS THEY COME OFF MACHINE Comment: INSPECT PARTS AS THEY COME OFF MACHINE



MM 16.00.0 10021615 , YEDITCHY Kim Johnston

Process Sheet

Custome: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 30592

Part Number: D2571

lob Number



Seq. #:

Machine Or Operation:

Description:

SECOND CHECK





Comment SECOND CHECK

HATID FINISHING!

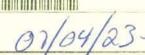
HAND FINISHING RESOURCE #1



Comment HAND FINISHING RESOURCE #1



Acid etch and Alodine as per QSI 005 4.1



0

POWDER COATING

103706



Comment. FOWDER COATING

Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3

INSPECT POWDER COAT/CHEMICAL CONVERS



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

identify and Stock

Location

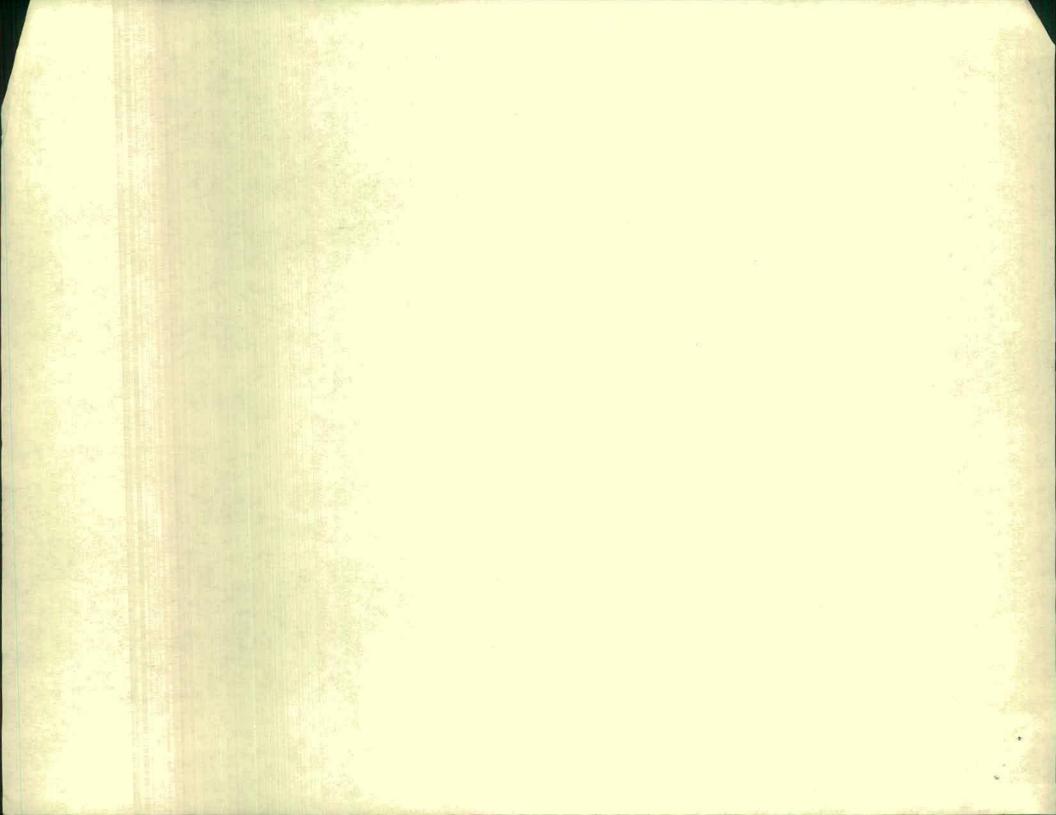
FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE





| DART AEROSPACE LTD | Work Order: | 30592 | |
|-----------------------------------|--------------|-------------|--|
| Description: Saddle, Fwd Outboard | Part Number: | D2571 | |
| Inspection Dwg: D2571 Rev. E | | Page 1 of 1 | |

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

| | | | | Recorded Actual Dimensions | | | | | 127 27 |
|-----|-------|-----------|-------------------|----------------------------|--------|-------------------------|-------|----|--------|
| Dim | Min | Max | Go/No Go Gauge | 1 | Ž | 2 | 3 | Ву | Date |
| A | 0.438 | 0.443 | DT8682 | 6440 | 0.440 | 0.440 | 0.446 | | |
| В | 1.745 | 1.755 | | 1749 | 1.788 | 1.749 | 1.748 | | |
| C | 3.495 | 3.505 | | 3 306 | 2.460 | 2.501 | 3.499 | | |
| D | 1.745 | 1.755 | | 1 256 | 7.998 | 1.745 7.999 2.499 | 1.748 | | |
| E | 7.990 | 8.010 | | 3.601 | 7.998 | 7.999 | 8.002 | 1 | |
| F | 0.490 | 0.510 | | | 0.4,99 | 0:496 | 0.497 | | |
| G | 0.257 | 0.262 | DT8683 | 0259 | - 250 | 200 | 0260 | | |
| H | 0.375 | 0.380 | DT8684 | 6.376 | .318 | -378 | 0.378 | | |
| 1 | 0.490 | 0.510 | | 3 30C | 0.502 | 0.501 | 6.563 | | |
| 4 | 1.174 | 1.184 | | 1.178 | 1.176 | 1.177 | 1.174 | | |
| K | 0.558 | 0.578 | | 5 54-8 | 1:176 | 0.568 | 0.568 | | |
| | 1.174 | 1.184 | | 1778 | 1.176 | 1.177 | 1.174 | | |
| M | 1.490 | 1.500 | | 495 | 1.494 | 1.177 | 1.493 | | |
| N | 2.495 | 2.505 | | 2 500 | 2.497 | 2.496 | 2.497 | | |
| 0 | 3.869 | 3.879 | | 3.871 | 3.871 | 3,871 | 3.872 | | |
| P | 0.115 | 0.135 | | 0./27 | 0.134 | 0.128 | 6 177 | | |
| C | 0.115 | 0.135 | | t. 135 | 0:135 | 0.135 | 0.135 | | |
| R | 0.240 | 0.260 | | 0.243 | 0 130 | 25A | 0253 | | |
| 6 | 0.115 | 0.135 | | 0135 | 0 130 | 0.134 | 0.130 | | |
| T | 0.178 | 0.198 | | 0 188 | 0.188 | 0.788 | 0/98 | | |
| U | 2.940 | 2.980 | | 2.945 | 2.960 | 2.960 | 2960 | | |
| V | 0.230 | 0.250 | | 0.242 | 0.230 | 0.241 | 8.238 | | |
| VV | 0.115 | 0.135 | | 0/32 | 0.125 | 6176 | 0.121 | | |
| X | 0.308 | 0.313 | | 0.310 | 6-311 | 0.311 | 0.311 | | |
| Y | 0.760 | 0.765 | | 0765 | 6.765 | 0.765 | 6.765 | | |
| Z | 0.352 | 0.372 | | | 0.364 | 0.765 | 6.369 | | |
| AA | 0.470 | 0.530 | | C-500 | 0-500 | 6 520 | 0.000 | | |
| AB | 0.615 | 0.635 | | C. 634 | 0.626 | 6.829 | 0.627 | | |
| AC | 0.053 | 0.073 | | 0.063 | 0063 | 0.063 | 0063 | | |
| AD | 0.240 | 0.260 | | 0.249 | 0.216 | 1.38 | 0.253 | | |
| AE | 1.375 | 1.395 | | 1.38 | 1386 | 1.385 | 1.787 | | |
| AF | 0.115 | 0.135 | | 51135 | 1386 | 6-135 | 0.135 | | |
| AG | 0.240 | 0.280 | | 2-260 | 0.260 | 0.260 | 0.260 | | |
| AH | 0.240 | 0.260 | | × 197 | 0.249 | 0.25% | 0.253 | | |
| Al | 2.000 | 2.020 | | 2,000 | 2000 | 2.000 | 2000 | | |
| AJ | 0.023 | 0.043 | | 5033 | 0033 | 0.033 | 0.033 | | |
| | Acc | ept/Rejec | et | | | | | | |

| Measured by: | - Orne | MR | 1 Em | Audited by | < \ |
|--------------|---------|------|----------|------------|---------|
| Date: | 07/01 | 1111 | 03/01/23 | Date: | 03.0423 |
| | Chamber | | | | |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| В | 02.09.24 | Re-format, Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension Al | KJ/RF | 1 |
| E | 05.12.05 | Added dimension AJ | KJ/JLM ZA | all |

